

April 5

Work Order ID 80177

\*80177\*

Page 1

February-13-12 10:40:43 AM

Item ID: D350-591-312

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: MLT

Date: 12/02/13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

0.00

0.00

S. Zickel 03

MLT 12-4-2

110

\*110\*

Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 119785

3-Grind End Plate flush 120169

0.00

0.00

12.03.13 5 0

12.03.13

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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**\*80177\***

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February-13-12 10:40:43 AM

Item ID: D350-591-312 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step, Long RH  
 Start Date: 13/02/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 05/04/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				<u>x5</u>	<u>0</u>	<u>BE 12/03/14</u>	
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<u>Size 1/4</u>		<u>(x5)</u> <u>RH</u>			
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00						<u>5x4 m-1 12/03/14</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

SRH d Jul 10 2015

180	Large Fab	0.00							
<b>*180*</b>									
Large Fab	Memo	0.00							
Large Fab									

- Memo**
- 1-Assemble Leg Assembly as per Dwg D3272.
  - 2-Leave one rivet out until welding is complete.
  - 3-Bevel Aft end for welding
  - 4-Inspect for foreign object as per QSI 024
  - 5-Weld Aft End Plate as per QSI 004 & Dwg D3272  
A/Aluminum Rod 119785
  - 6-Grind End Plate flush
  - 7-Install last rivet as per Dwg.

→ Ac 12.03.17  
 12.03.19

(X5) Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00		PC12.03.20		5x	0		
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							12.03.20 (5)
210 <b>*210*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				5			12.3.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 05/04/2012 Req'd Qty: 5.00 **\*5\*** Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*220*</b> Powdercoat Powder Coating	Memo START TIME: <u>10h20</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>10h50</u>	0.00				<u>5</u>	<u>0</u>	<u>(JP)</u>	<u>12/03/30</u>
				<u>M120222</u>					
230	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
<b>*230*</b> HandFinish Hand Finishing	Memo	0.00							<u>SX Ø m/12/03/30</u>
				<u>M120459</u>					
240	QC3- Inspect Part Finish	0.00							
<b>*240*</b> QC Quality Control	Memo	0.00							<u>5 BL 12-3-30.</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Start Date: 13/02/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

(5) SP 12-04-02. s/f

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

Sizeloz

(5) AH

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312  
Location: \_\_\_\_\_

gx SP 12-04-04

Rev B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*80177\***

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12/4/5

R204-S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

February-13-12 10:40:47 AM

Page 1

Work Order ID: 80177

\*80177\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	20.0000	1	5			

\*D3272-1\*

Step

\*\*

12.03.12

## Location

## Loc Qty

## Loc Code

ST B80179 -10  
WA 30  
78784 10  
78788 10

D3067-1

Manufactured No

110 Each

106.0000

1

5

\*D3067-1\*

End Plate

\*\*

12.03.13

## Location

## Loc Qty

## Loc Code

WA B78608 28  
78022 28  
WA016 78  
67582 2  
68214 1  
79607 75

5

W/O:		WORK ORDER CHANGES					
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Work Order ID: 80177

**\*80177\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3219-1 Manufactured No

110 Each 160.0000 2 10

**\*D3219-1\***

\*\*

Plate

*12.03.13*

Location

Loc Qty

Loc Code

WA016

160

73410

12

77674

6

78763

142

*10*

D3066-1 Manufactured No

180 Each 146.0000 2 10

**\*D3066-1\***

\*\*

Spacer

*12.03.17*

Location

Loc Qty

Loc Code

WA

146

~~78605~~

106

79729

40

*x10*

MS20600-AD4W4 Purchased No

180 Each 2,618.000 16 80

**\*MS20600-AD4W4\***

\*\*

Rivets

*12.03.17*

Location

Loc Qty

Loc Code

ST321

2613

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

30

119883

155

120308

632

WA018

5

116712

5

*x80*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3065-041 Manufactured No

180 Each

14.0000 1 5

**\*D3065-041\***

Step Leg Assembly Hi

\*\*

B 78799 (x5) Ae 12.03.17

Location

Loc Qty

Loc Code

WA

14

66149

0

78797

13

79336

1

D3067-1 Manufactured No

180 Each

106.0000 1 5

**\*D3067-1\***

End Plate

\*\*

12.03.20

Location

Loc Qty

Loc Code

WA

28

78022

28

WA016

78

67582

2

68214

1

79607

75

Purchased No

250 Each

177.0000 2 10

AN3-35A

**\*AN3-35A\***

Bolt

\*\*

B/D10608SD 12-04-03

Location

Loc Qty

Loc Code

ST353

177

120187

127

120644

50

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3235-1 Manufactured No

250 Each

25.0000

**\*D3235-1\***

Mounting Lug

2 10

\*\*

B78787 SP SP

Location

Loc Qty

Loc Code

ST471

20

77566

20

ST481

5

75547

5

D3278-041 Manufactured No

250 Each

41.0000

**\*D3278-041\***

Support Assembly

1 5

\*\*

B78795 SP SP

Location

Loc Qty

Loc Code

ST481

41

77057

1

78794

40

AN960JD416 NAS1149D0463J Purchased No

250 Each

8.0000

**\*AN960.ID416\***

Washer

16 80

\*\*

m21011 SP SP

Location

Loc Qty

Loc Code

ST351

8

116289

8

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

**\*AN960.ID516\***

Washer

AN5-36A

Purchased No

250 Each

207.0000

**\*AN5-36A\***

Bolt

4 20

\*\*

SP 119717 SP

2 10

\*\*

SP 12-04-03 SP

Location

Loc Qty

Loc Code

ST340

207

120187

192

120423

15

10x

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

D2618  
**\*D2618\***  
Bushings

Manufactured No

250 Each

206.0000

\*\*

10

Location

Loc Qty

Loc Code

ST012

206

76130

2

77563

4

78537

200

Manufactured No

250 Each

16.0000

\*\*

20

D2230-3  
**\*D2230-3\***  
Lug

Location

Loc Qty

Loc Code

ST480

16

53881

4

70973

1

77561

11

Manufactured No

250 f

241.0073

1.2

6

\*\*

D2856-400  
**\*D2856-400\***  
Abrasion Strip

Location

Loc Qty

Loc Code

ST409

241.007258

63735

0.6696

68076

0.3149

71164

21.66

73491

2.362758

79551

216

cut (2) D2856-400-720 as per dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February-13-12 10:40:47 AM

Work Order ID: 80177

\*80177\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

250

Each

4,835.000

2

10

\*MS21042L3\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

4835

117441

25

117885

32

118451

5

118927

3

119017

4372

119075

398

\*\*

2

10

AN4-13A

Purchased

No

250

Each

1,357.000

8

40

\*AN4-13A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST357

1357

119449

59

120187

798

120422

500

\*\*

8

40

MS21042L5

Purchased

No

250

Each

1,790.000

2

10

\*MS21042L5\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

1790

116105

5

116548

43

117611

42

118179

200

119109

1500

\*\*

2

10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-13-12 10:40:47 AM

Page 7

Work Order ID: 80177

**\*80177\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 13/02/2012

Required Date: 05/04/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

250

Each

5,401.000

8 40

**\*MS21042L4\***

Nut

Location

Loc Qty

Loc Code

ST300

5401

117441

59

117601

157

118451

133

119017

200

119075

4852

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

**\*AN960JD10\***

Washer

\*\*

20

m12day4

SP 12-04-02

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*3/12/2012  
2:37 PM  
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

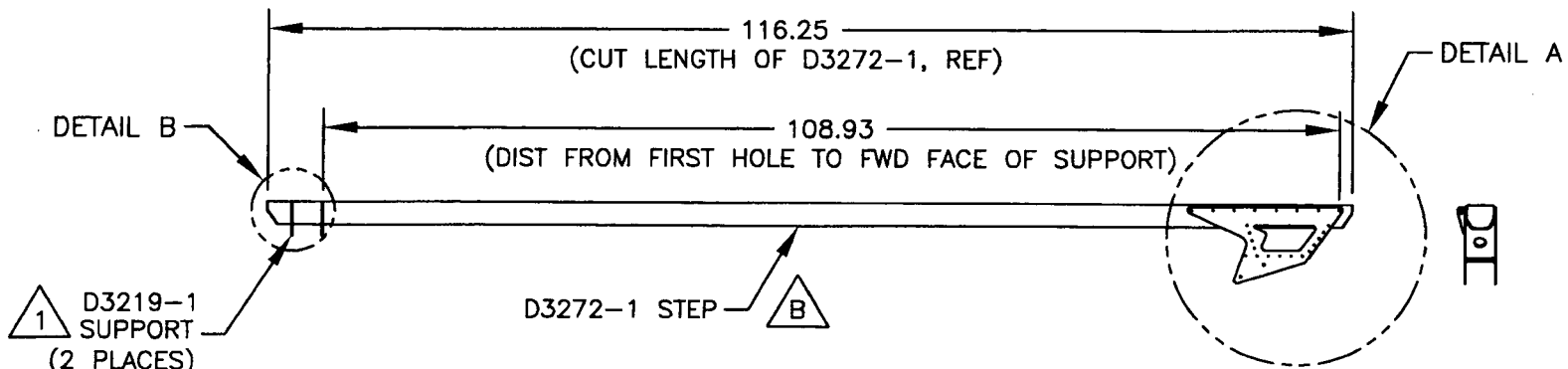
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

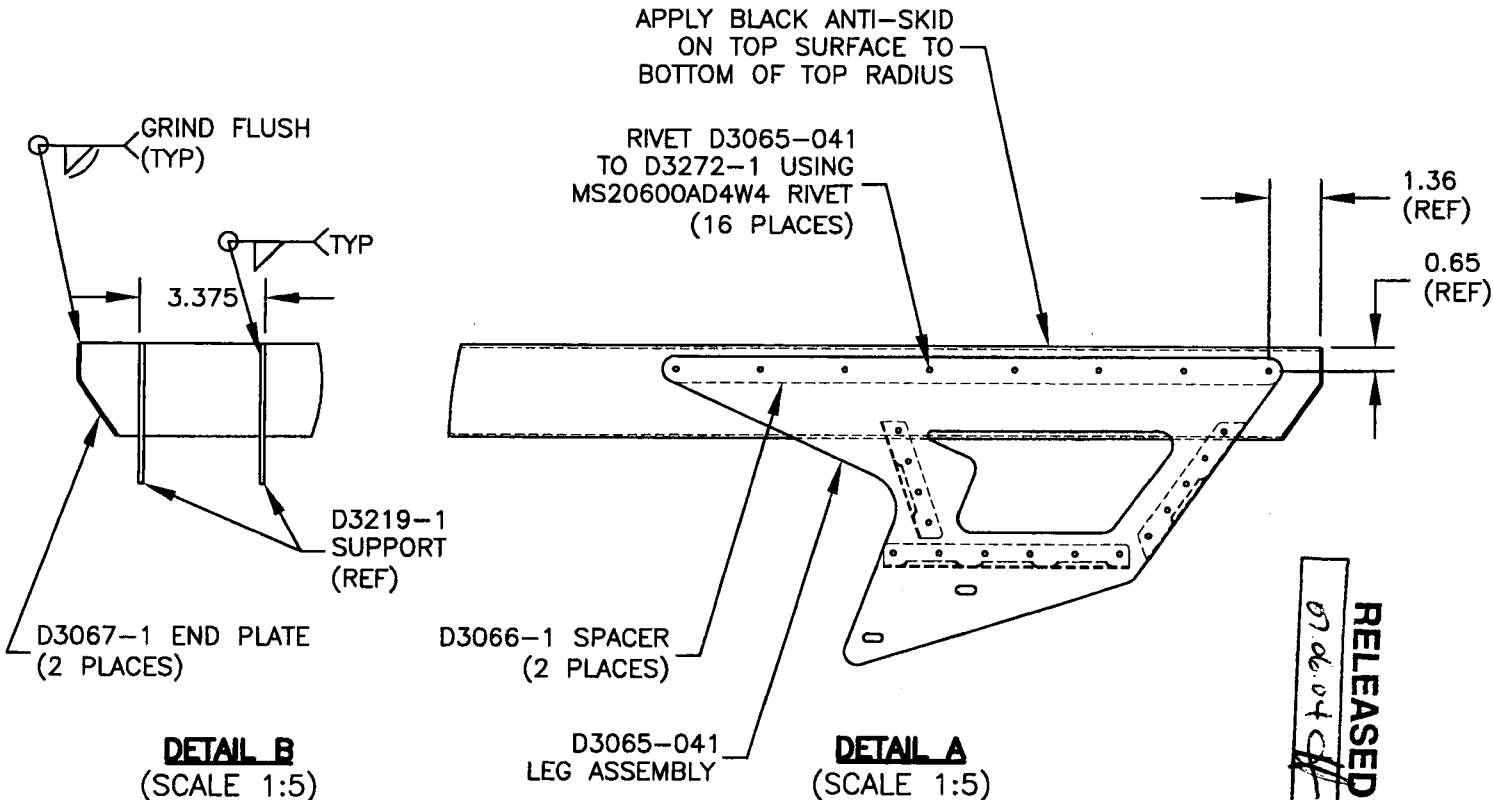
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80177



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



RELEASED  
 07.06.04

DESIGN	AP	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



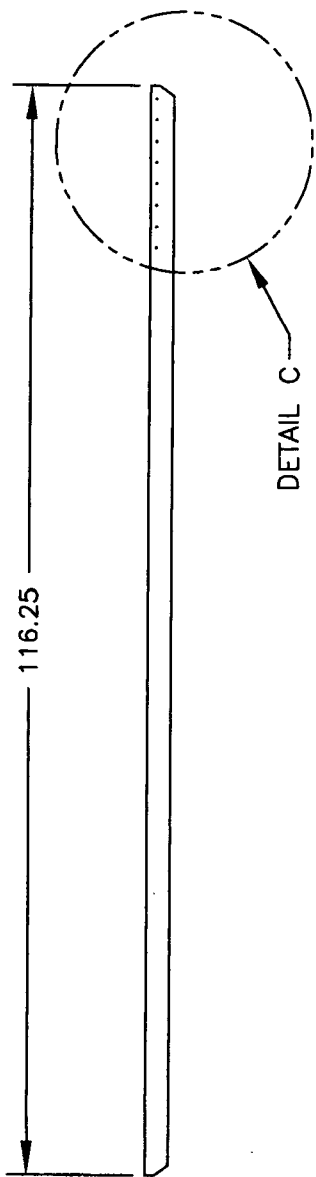
42108



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

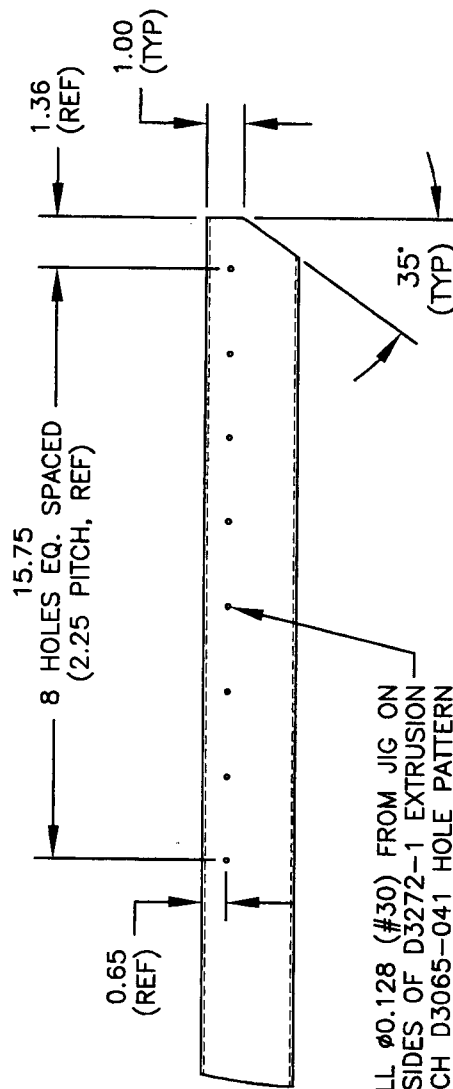
RELEASED

07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
	X							D350-591-212	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
		X						D350-591-213	<b>Heli-Access-Step™</b> , Short Step – High Skid, LH
			X					D350-591-214	<b>Heli-Access-Step™</b> , Short Step – High Skid, RH
				X				D350-591-215	<b>Heli-Access-Step™</b> , Short Step – Low Skid, LH
					X			D350-591-216	<b>Heli-Access-Step™</b> , Short Step – Low Skid, RH
						X		D350-591-311	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
							X	D350-591-312	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.